: WEARPLATE

· D2577 REV E

: D25775

: N/A

NIA

: 3/15/2007

Date:

Thursday, 2/22/2007 2:57:30 PM

User:

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer Job Number : CU-DAR001 Dart Helicopters Services

Estimate Number

: 10299

P.O. Number

: NA

This Issue Prsht Rev.

: 2/22/2007

: NC

S.O. No. : 47

: SMALL /MED FAB

Previous Run Written By

First Issue

: 28639

Checked & Approved By Comment

02.09.24 Re-format KJ/RF : Est:

Est Rev:D Now on Waterjet 06-06-14 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: 1010/1025/A21/6aA SHEET

1.0

M1010S16GA

Comment: Qty.:

1.0301 sf(s)/Unit

Total: 30.9015 sf(s)

1010/1025 16GA SHEET

(m1010s16ga)

07105114

2.0



Comment: FLOW WATER JET

1-Cut as per Dwg D2577 Dwg Rev: Prog Rev:

2-Deburr if necessary

SAN 07/05/14

INSPECT PARTS AS THEY COME OFF MACHINE





SECOND CHECK

Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2577-5T1

4.0

QC8

Comment: SECOND CHECK

5.0

SMALL FAB

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr





Dart Aerospace Ltd

W/O:		WORK ORDER CHAI	NGES	· · · · · · · · · · · · · · · · · · ·			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					· .		
•							
				<u></u>			

Part No:	PAR #:	_ Fault Category:	<u>:</u>	NCR: Yes No DQA:	Date: <u>07/05/3/</u>
				QA: N/C Closed:	Date:

Corrective Action Section B Verification Approval Approval
al Action Description Sign & Section C Chief Eng QC Inspects

NOTE: Date & initial all entries

	rsday, 2/22/2007 2:57:30 PM	• ,		
_n User: Kim	Johnston	Process Shee	et	
Customer:	CU-DAR001 Dart Helicopters Se	rvices Drawing	Name: WEARPLATE	
Job Number:	30812	Part N	umber: D25775	
Job Number:				
Seq. #:	Machine Or Operation:		Description :	
6.0	BRAKE NC	NC BRAKE		
Comme	nt: NC BRAKE			
	1-Form on brake using DT8 2-Form joggle using DT815 3-Identify as D2577-5	155 and DT8179 as per Dwg D2577 7 as per Dwg D2577	SB	07/05/25
7.0	QC5	INSPECT WORK TO CO		
	nt: INSPECT WORK TO CURF			
8.0	POWDER COATING	POWDER COATING		34
Comme	nt: POWDER COATING		BO/mil o	1/05/29
9.0	QC3	(Ref. 4.3.5.6) as per QSI 005 4.3 INSPECT POWDER CO	DAT/CHEMICAL CONVERSION	11-5/21
10.0	nt: INSPECT POWDER COATA PACKAGING 1	CHEMICAL CONVERSION PACKAGING RESOUR	$\frac{1}{CE \pm 1}$ $\frac{1}{CE}$ $\frac{1}{$	-130 (34)
10.0		17/0/V/OING NEGGGIV		
Comme	nt: PACKAGING RESOURCE	#1		-0-
	Identify and Stock Location:	a.m	07/05/30	(34)
11.0	QC21	FINAL INSPÉCTION/W	ORELEASE	<u>3</u> j
Comme	nt: FINAL INSPECTION/W/O F	RELEASE	9	CAKIS131
Job Completion *			W D.	10531
†				,
		•		
		•		
		. •		

Dart Aerospace Ltd

W/O:		WORK ORDER C	CHANGES
DATE	STEP	PROCEDURE CHANGE	By Date Qty Approval Chief Eng / Prod Mgr QC Inspector
Part No		PAR #: Fault Category:	NCR: Yes No DOA: Date:

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORDE	ER NON-CONFORMANC	E (NCR)			
v ⁻		Description of NC		Corrective Action Section B	··	Verification	A	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
							ļ.	
						1		
						6.	7	
) (A)		
						,.* .		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30812
Description: Wearshoe	Part Number:	D2577-5
Inspection Dwg: D2577 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

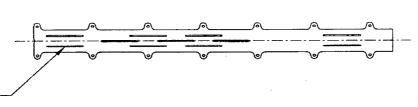
Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension				
2.50	+/-0.030	2.501		<u> </u>	neishi cya	Ege
3.182	+/-0.010	3.187			Vern	
43.50	+/-0.030	43.50	سر.		M-T	
38.500	+/-0.010	38.500			M-T	
2.50	+/-0.030	2.498			te height	Jauge L
2.43	+/-0.030	2,49			Vern	/ /
R0.129	+/-0.010	RO.129			R-6	
0.220	+/-0.010	0.218	/		Vern	
0.300	+/-0.010	0.299	/		Vern	
0.375	+/-0.010	0.370	1		Height soas	e
0.063	+/-0.010	0.062			Vern	

Measured by:	500	Audited by:	MS	Prototype Approval:	N/A
Date:	07/05/14	Date:	07/05/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.12.07	New Issue	KJ/JLM A	E

COPIED

7560 HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH (TYP. 11 PLS.) WELD AFTER BENDING AS ILLUSTRATED PER DT8308



D2577-1 & D2577-3 WEARSHOE MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





OF OF STATES

CHECKED CHECKED CHECKED CATE DATE OO.09.22 A B B	.22	APPROVED 96.09.16 96.12.04 97.05.30	DART AE HAWKESBU DRAWING NO. D2577 TITLE WEARSHOE NEW ISSUE ADD HARDCOAT I CHANGE HOLES
12 120	2	APPROVED APPROVED 96.09.16	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA PRAWING NO. PREV. E D2577 TITLE WEARSHOE NEW ISSUE
1.3			
		96.09.16	NEW ISSUE
		96.12.04	ADD HARDCOAT WELDS
		97.05.30	CHANGE HOLES TO OBROUNDS
		98.08.17	CORRECTED DIMENSIONS ON -1 & -3
		00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176

D2941-300	SHOP COPY RETURN TO RETURN TO RETURN TO RIGINEERUN ENGINEERUN ENGI	
SHWAYDER WEAPADS (8 PLACES)	OPY LLED COPY AMENDMENT AM	SECTION A-A SCALE 1:5 R2.00 \
A 1.50 (TY	P)	D2941-300 (REF)
	0.12 (TYP)	REMOVE POWDER COAT FROM THESE SURFACES

D2577-21 & D2577-23 WEARSHOE MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





00.09.22

D2577

WEARSHOE SHEET 2 OF

SCALE

R0.128 -2.50 -(REF) (2 PLACES) SEE DETAIL B ON PAGE 5 2.43 --- 6.000 3.182 18.000 24.000 30.000 36.000

D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

1010-1025 OR ASTM A36/A366/A569/A570 MATERIAL:

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

8.50 → ON FLAT	R50.0
SHOP COPY RETURN TO RETURN TO RETURN TO RETURN TO REMORERIN WORK OF	SEE DETAIL C ON PAGE 5 FOR D2577-11 ONLY
TO T	D

D2577-11 & D2577-13 LONGITUDINAL BEND MAKE FROM D2577-101 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

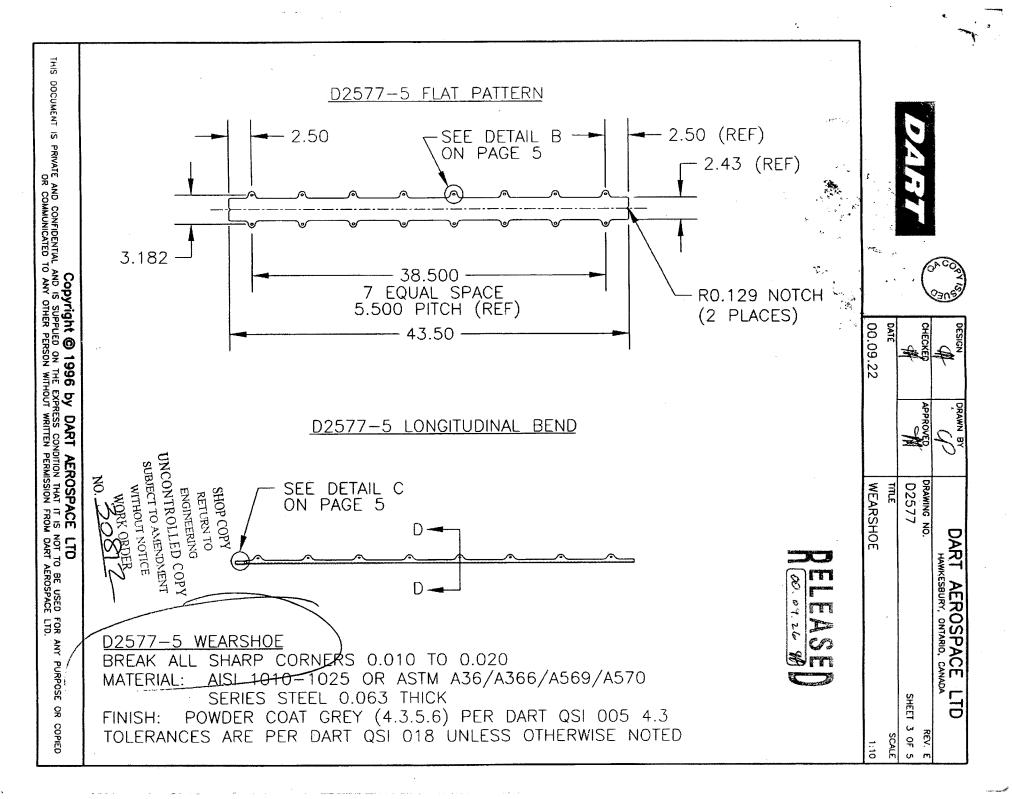
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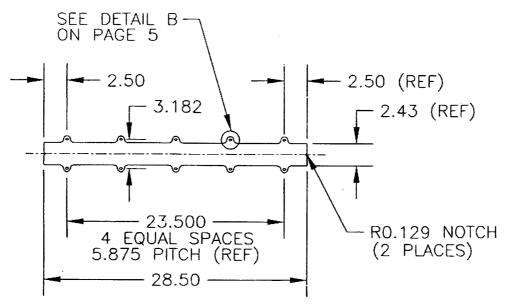


LTD

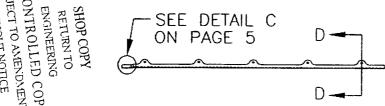
SHEET

4 OF SCALE

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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D2577-7 WEARSHOE

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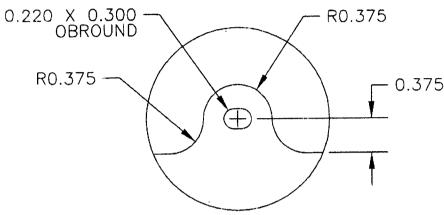




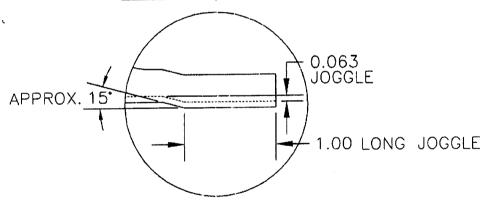
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
GF -	A	D2577	SHEET 5 OF 5
DATE		TITLE	SCALE
00.09.22		WEARSHOE	1:10

DETAIL B (SCALE 1:1)

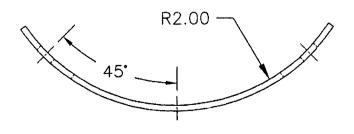




DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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WORK ORDER

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